

Tuesday, 4/4/2006 1:36:31 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY
 Job Number : 26535
 Estimate Number : 10699
 P.O. Number :
 This Issue : 4/4/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D3391025
 First Issue : / / Type : LANDING GEAR Drawing Number : D3391 REV D
 Previous Run : 26534 Project Number : N/A
 Material :
 Due Date : 5/5/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 06.04.04
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC
 Est Rev:C 06-03-28 Update Manufacturing Instructions JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description

1.0

D6014090

ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 24315 (D6014-104)

MS 06/04/06

Identify as D3391-3

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: D

MS 06/04/07

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/04/07

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: ____ & Dwg D3391 Rev: ____


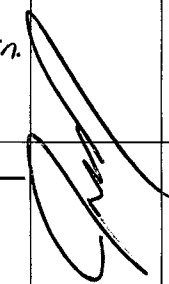
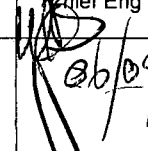
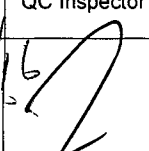


2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/07	2	Turnet hit steady rest, therefore making a mark with the tool on the tube. Measurement is to the most face section of the steady rest. On the face of the steady rest there are knobs. This is where they were supposed to measure from.		Tube is Scrap. Note this detail on the Polio Dwg to ensure this won't happen again. dimension corrected to face of steady rest. See Attache Polio Dwg.		06-05-16		
			06/05/16	Scrap replace tube on this wro		" "		" "

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26535

Part Number: D3391025

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

7.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: NC Bender
Form as per Dwg D3391 Using Bend Prog 3391025

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

9.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

- 1-Open Aft cap pilot hole to .208" as per Dwg D3391
- 2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)
- 3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig
- 4-C'sink holes for float bag (4 holes per side) as per Dwg D3391
- 5-Deburr

Tools: rill

10.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26535

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

15.0

NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

16.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert

or NAS1330C3KB266

17.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB316 Insert

or NAS1330C3KB316

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26535

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	

19.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	

20.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	

21.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291

Sikaflex expiry date:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:36:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26535

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W 07.09.09

Dart Aerospace Ltd

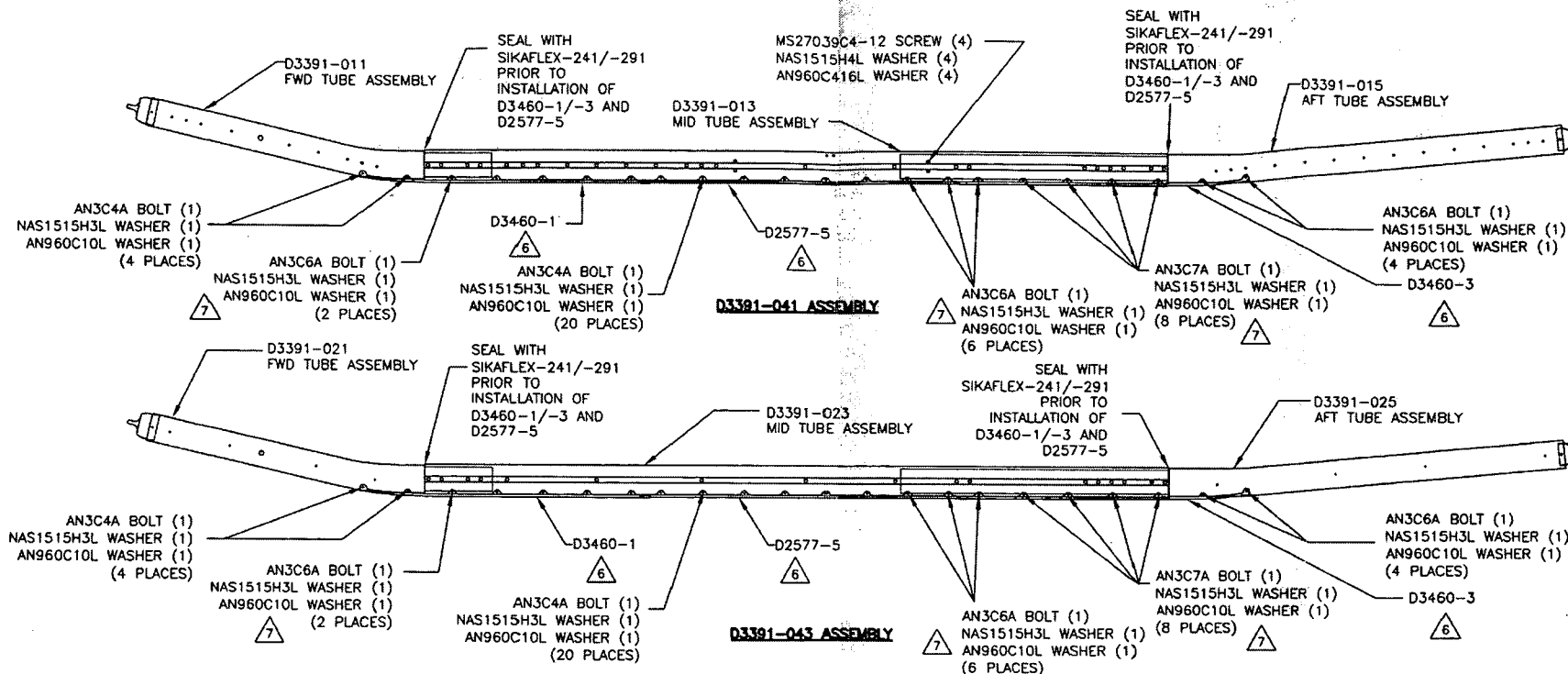
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- DO NOT TORQUE, HAND TIGHTEN ONLY

△

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 26535

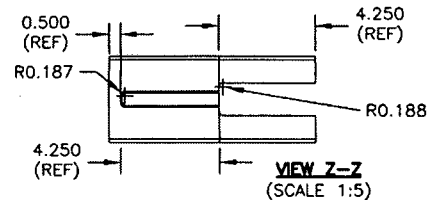
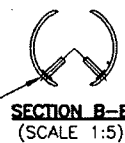
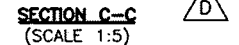
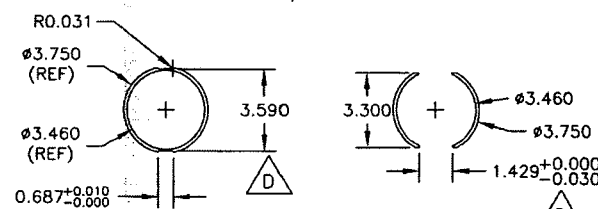
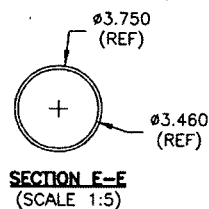
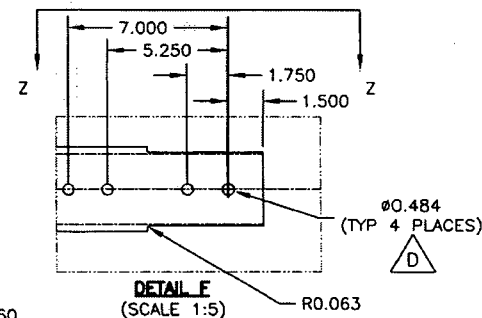
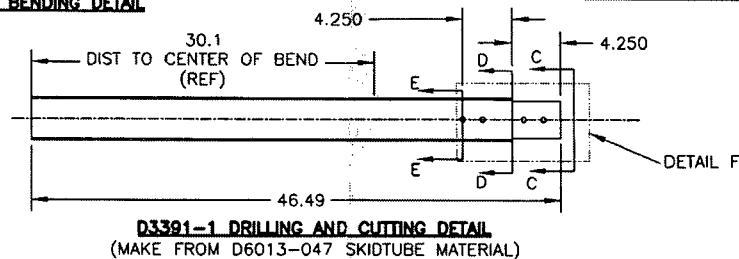
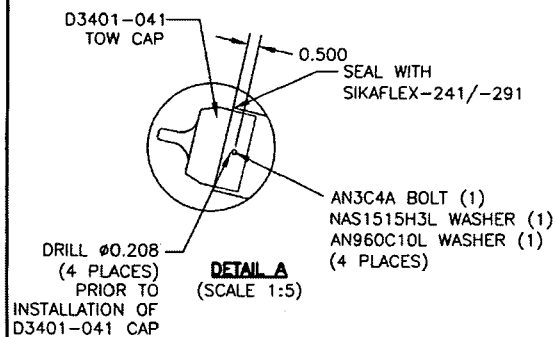
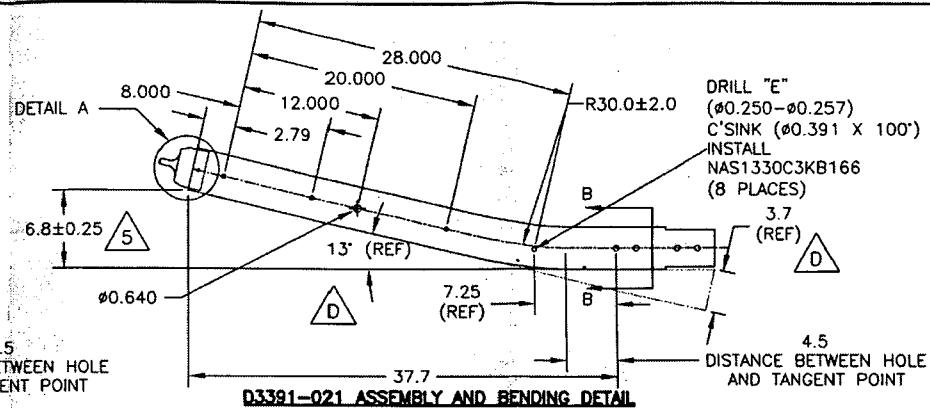
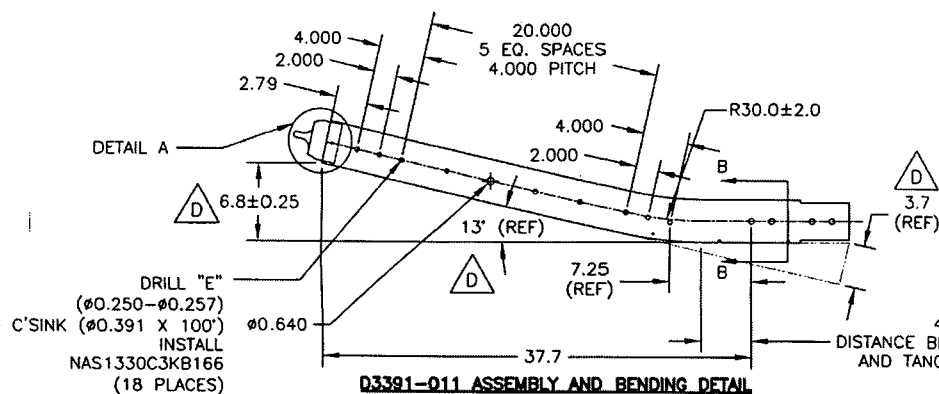
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DESIGN	D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
	C	05.09.27	LENGTHEN AFT EXTENSION
	B	05.06.10	DRAWING UPDATES
	A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY	PH
CHECKED	#	APPROVED	#
DATE	06.01.23	DRAWING NO.	D3391
		TITLE	412 FLOAT SKIDTUBE
		REV. D	SHEET 1 OF 5
		SCALE	NTS

RELEASED

06.01.27



D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

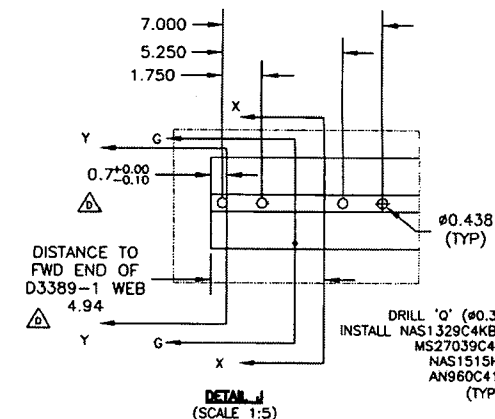
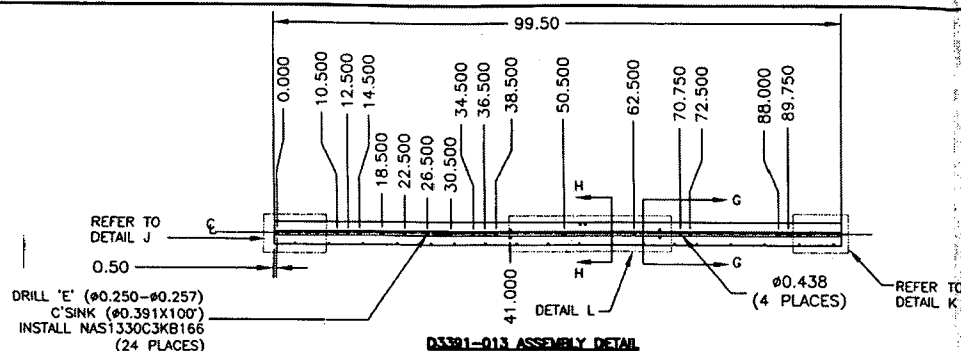
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

NO. 26535
WORK ORDER
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5 DRILL 'E' (Ø0.250-Ø0.257) C'SINK (Ø0.391 X 100') INSTALL NAS1330C3KB166 (6 PLACES)

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DESIGN PH
CHECKED PH
DATE 06.01.23
DRAWN BY PH
APPROVED PH
DART AEROSPACE USA, INC.
PORT HADLOCK, VA
DRAWING NO. D3391
TITLE 412 FLOAT SKIDTUBE
REV. D
SHEET 2 OF 5
SCALE 1:10



DRILL 'G' (#0.332-#0.338)
INSTALL NAS1329C4KB140 INSERT
MS27039C4-08 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

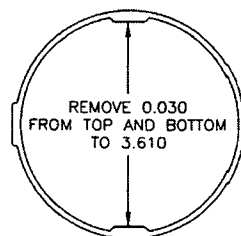
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	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

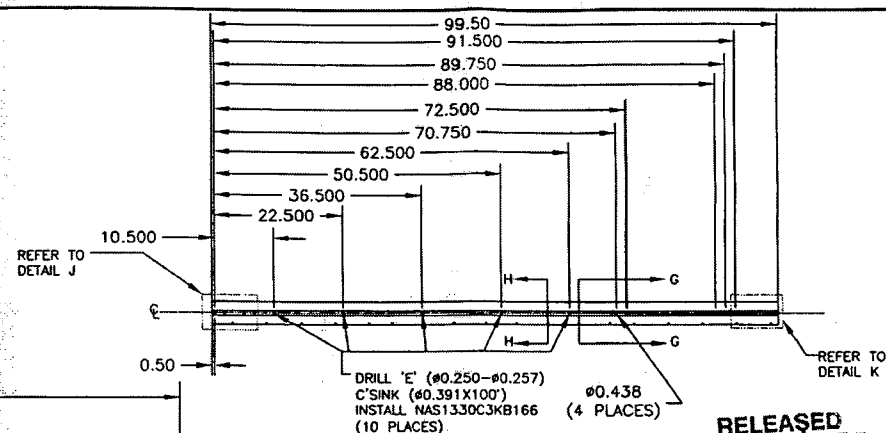
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-2417-291 PER 059-013

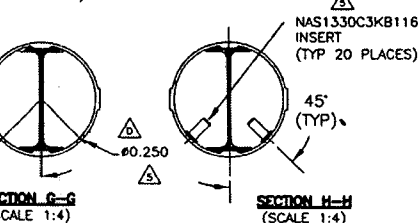
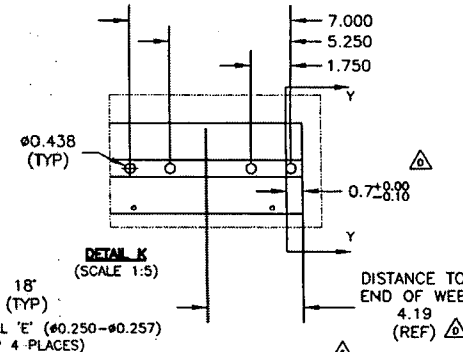
SECTION I-I (SCALE 1:4)



SECTION X-X (SCALE 1:2)



D3391-023 ASSEMBLY DETAIL



REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

SECTION Y-Y (SCALE 1:4)

SECTION G-G (SCALE 1:4)

SECTION H-H (SCALE 1:4)

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DESIGN PH
CHECKED PH

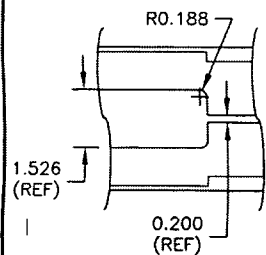
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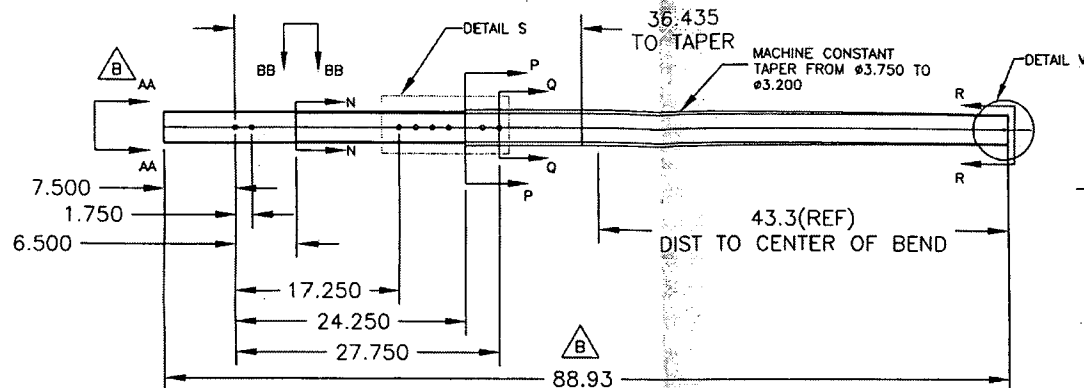
DATE
06.01.23

DRAWING NO.
D3391
TITLE
412 FLOAT SKIDTUBE
REV. D
SHEET 3 OF 5
SCALE
1:20

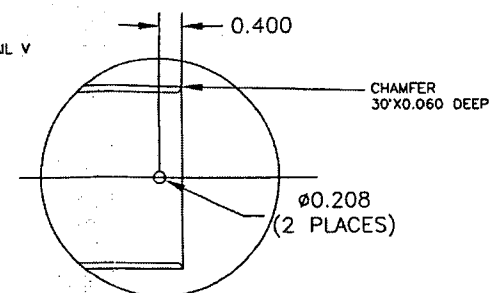
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VIEW BB-BB
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D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



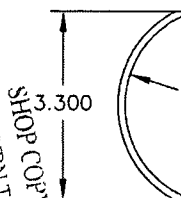
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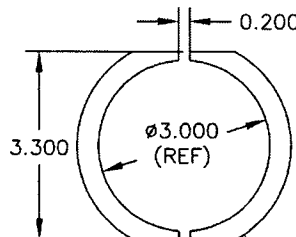
06.01.23

1.526^{+0.000}_{-0.030}

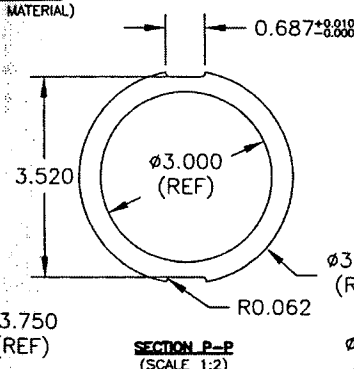
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WORK ORDER
SUBJECT TO ATTENDANT
WITHOUT NOTICE
UNCONTROLLED COPY
RETURN TO
SHOP COPY
ENGINEERING



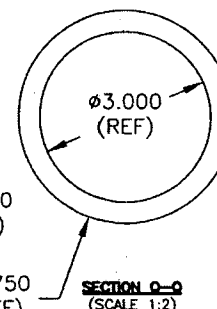
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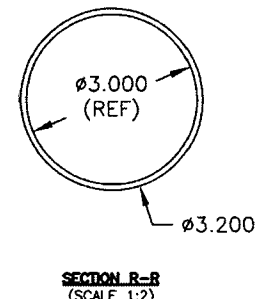
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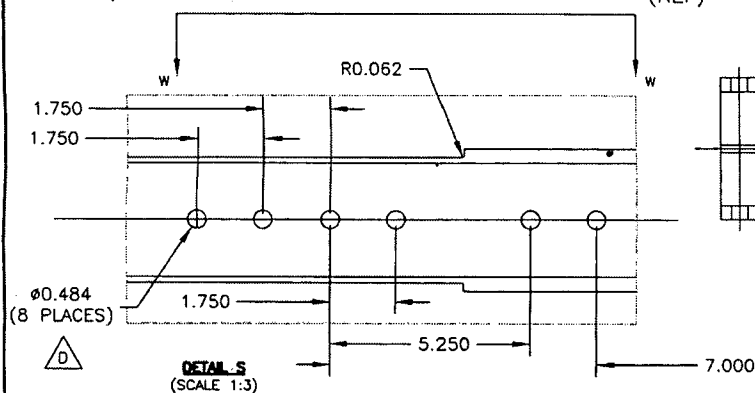
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(SCALE 1:2)



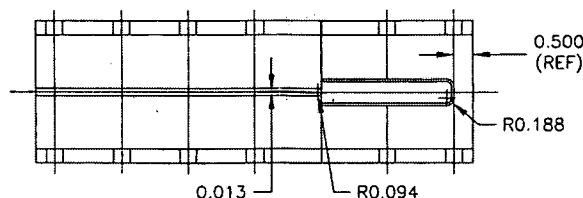
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



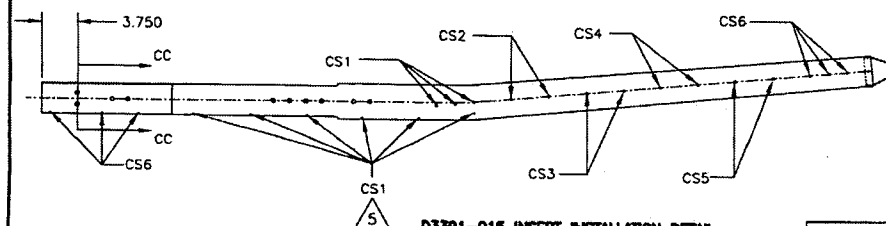
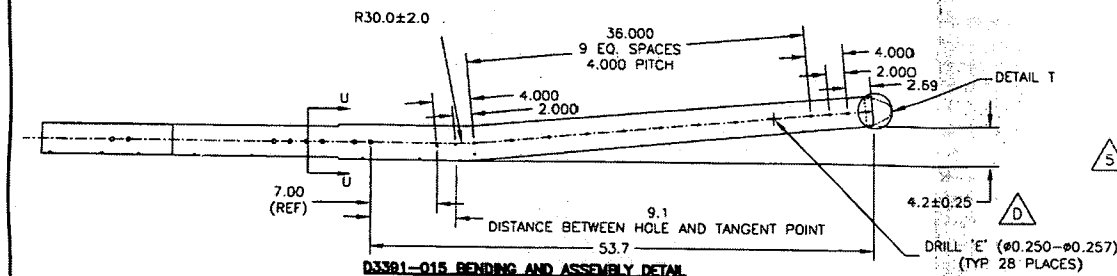
VIEW W-W
(SCALE 1:3)

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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, MA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3391	SHEET 4 OF 5
DATE	TITLE	SCALE	
06.01.23	412 FLOAT SKIDTUBE	1:12	

RELEASED
06.01.27



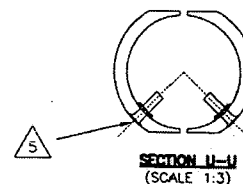
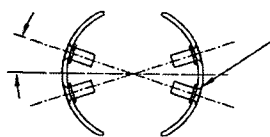
C'SINK AND INSTALL AESS10KBXXX AND/OR
NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS
FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	4		Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KB316
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4		Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

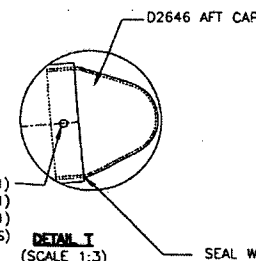
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER

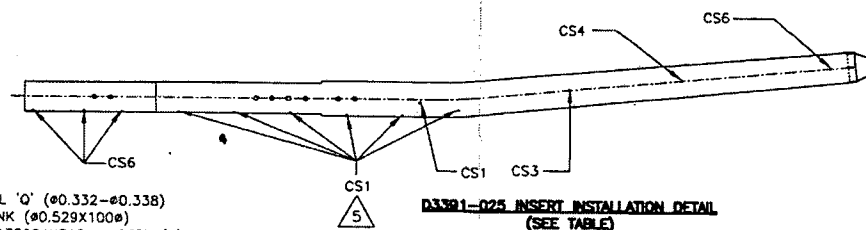
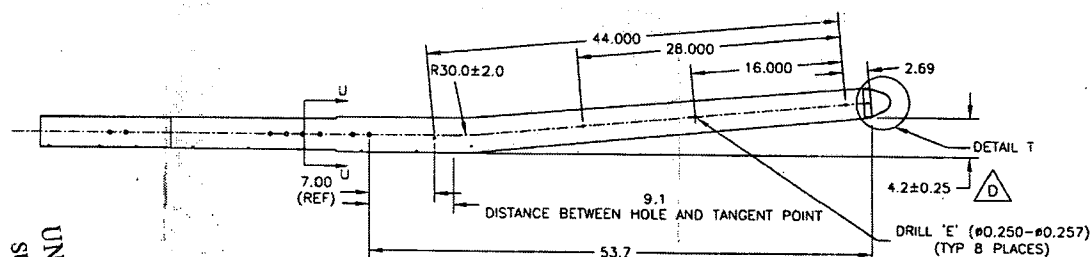
NO. 26535
WORK ORDER
18" (TYP)
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SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)



SEAL WITH
SIKAFLEX-241/-291



DRILL 'Q' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100Ø)
NAS1330C4KB151 INSERT (1)
(4 PLACES)

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CHECKED [Signature]	APPROVED [Signature]	
DATE 06.01.23	DRAWING NO. D3391	REV. 0 SHEET 5 OF 5
TITLE 412 FLOAT SKIDTUBE		SCALE 1:12

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

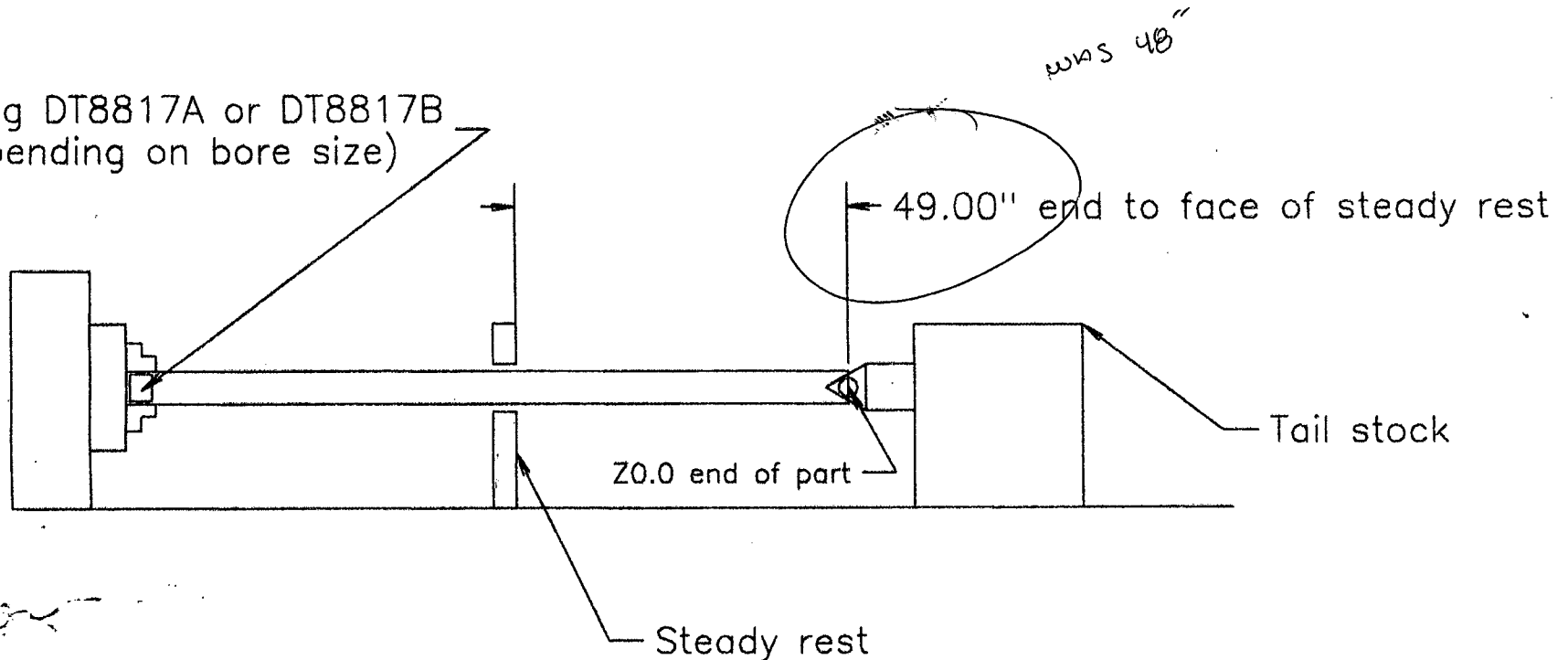
Measured by: 		Audited by:		Prototype Approval:	
Date: 06/04/07		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

REFERENCE ONLY

2nd OP PRG #1005

Insert plug DT8817A or DT8817B
(Depending on bore size)



- 1—Flip Tube Around to turn taper side.
- 2—Face tube to length manually before running prog. 1005